

2022 CHEVROLET CORVETTE SERVICE MANUAL

- **SEARCH**

1. **Body Repair**
2. **Collision Repair**
3. **Repair Instructions**
- 4.

Load Floor Panel Assembly Replacement

Materials

- Structural Adhesive Aluminum Panel Bonding
- Structural Rivet (SR2 10X) Fastener Specifications
- Countersunk Structural Blind Rivet (CR2 10X) Fastener Specifications

Removal Procedure

1. [Click here for full size](#)
2. **Warning:**

Refer to Approved Equipment for Collision Repair Warning
3. **Warning:**

Refer to Collision Sectioning Warning
4. **Warning:**

Refer to Glass and Sheet Metal Handling Warning
5. **Note:**

The load floor panel assembly is 6000 series aluminum. Aluminum
6. **Note:**

Left shown, right similar.
7. **Note:**

Three dimensional measuring equipment required for installation.
8. Disable the SIR system. SIR Disabling and Enabling
9. Remove all related panels and components.
10. Remove front floor panel. Front Floor Panel Replacement
11. Remove floor panel number 3 cross bar. Floor Panel Number 3 Cross Bar Replacement
12. Remove the sealers and anti-corrosion materials from the repair area as necessary. Anti-Corrosion Treatment and Repair
13. [Click here for full size](#)
14. **Note:**

Record the number and location of spot welds for installation of structural rivets.
15. **Note:**

Do not damage or cut attaching panels and reinforcements.
16. Remove spot welds (1). [10X] Fastener Specifications
17. [Click here for full size](#)
18. **Warning:**

Refer to Aluminum Panel Warning.

19. Note:

Use even pulling strokes to control cut.

20. Note:

Do not damage or cut attaching panels and reinforcements.

21. Using belt sander or similar tool, cut through remaining portion of back body pillar lower reinforcement (1) to remove laser weld.

22. [Click here for full size](#)

23. Warning:

When separating the aluminum panels during collision repair, be sure to adhere to the following precautions:

- Do not use an open flame
- Focus heat onto panel being replaced and do not exceed 200°C (392°F) for 3 consecutive minutes
- Use care not to damage adjacent panel while prying the panels apart

Failure to follow the precautions may lead to vehicle damage or personal injury.

24. Apply heat to release adhesive (1).

25. [Click here for full size](#)

26. Remove load floor panel assembly (1) from vehicle.

27. Note:

Do not damage body structure when removing adhesive.

28. Remove remaining adhesive from body structure.

Installation Procedure

1. [Click here for full size](#)

2. Note:

Temporarily install replacement part.

3. Position load floor panel assembly (1) on vehicle using three-dimensional measuring equipment and clamp into place.

4. [Click here for full size](#)

5. Note:

The 6.7 mm (17/64) holes are used for rivet installation.

6. Note:

Drill holes in the original spot weld location as noted in removal.

7. Drill 6.7 mm (17/64) holes (1) for countersink structural blind rivets. [10X] Fastener Specifications

8. Drill 6.7 mm (17/64) holes (2) for countersink structural blind rivets. [10X] Fastener Specifications

9. Note:

Prepare rivet holes for countersunk structural rivets.

10. Using countersink cutting tool, countersink holes (1). [10X] Special Tools

11. [Click here for full size](#)

12. Remove load floor panel assembly (1) from vehicle.

13. [Click here for full size](#)

14. Note:

Accurate and timely assembly methods must be used in order to meet proper bonding requirements.

15. Note:

Dry fit all parts with proper clamping devices prior to final assembly to ensure full understanding of the assembly process.

16. Note:

When using adhesive, ensure all necessary tools and materials are in place prior to final assembly.

17. Note:

Only remove E-coat where adhesive will be applied.

18. Note:

Ensure all bare metal is covered.

19. Clean and prepare mating surfaces on structure and replacement part according to adhesive manufacturer's recommendations.
Aluminum Panel Bonding

20. Apply structural adhesive (1) to mating surfaces on structure and replacement part according to adhesive manufacturer's recommendations. Aluminum Panel Bonding

21. [Click here for full size](#)

22. Install load floor panel assembly (1) on vehicle and clamp into place.

23. [Click here for full size](#)

24. Note:

Install fasteners from direction shown.

25. Install countersunk structural blind rivet (1). [CR2 10X] Fastener Specifications

26. Install structural rivet (2). [SR2 10X] Fastener Specifications

27. Remove excess adhesive.

28. Seal structural rivets with seam sealer. Anti-Corrosion Treatment and Repair

29. Install front floor panel. Front Floor Panel Replacement

30. Install floor panel number 3 cross bar. Floor Panel Number 3 Cross Bar Replacement

31. Apply the sealers and anti-corrosion materials to the repair area as necessary. Anti-Corrosion Treatment and Repair

32. Paint the repaired area. Basecoat/Clearcoat Paint Systems

33. Install all related panels and components.

34. Enable the SIR System. SIR Disabling and Enabling